

Work Order ID 61016

August 4, 2010 8:57:30 AM



Page 1

Item ID:	D4151-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Eyebolt Receiver (Upper)					
Start Date:	8/04/10	Start Qty:	8.00		Cust Item ID:	
Required Date:	8/11/10	Req'd Qty:	8.00		Customer:	
Reference:					Run	Start
Approvals:	Process Plan:	Date:	10-8-04	Tooling:	Date:	
	QC:	Date:		SPC (Y/N):	Date:	
					Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	B								

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank to 2.885" long

0.00

0.00

10.8.9

8 0

110



HAAS 1

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA952 & dwg,

FOLIO REV: AA

DWG REV: 13

2-Deburr as required

0.00

0.00

10.8.9

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date:			

NOTE: Date & initial all entries

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Page 2

Item ID: D4151-7

Accept



Setup Start



Revision ID:

Item Name: Fwd Eyebolt Receiver (Upper)

Stop



Start Date: 8/04/10 Start Qty: 8.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>10.8.9</i>			<i>8</i>	<i>0</i>		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>10/08/10</i>			<i>8</i>	<i>0</i>		
140 Packaging Packaging	Identify as per dwg & Stock Location: <i>127</i> Memo	0.00 0.00				<i>10/8/10</i>	<i>SP</i>	<i>(80)</i>	

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Page 3

Item ID: D4151-7

Accept



Setup Start

Revision ID:

Item Name: Fwd Eyebolt Receiver (Upper)

Stop



Start Date: 8/04/10 Start Qty: 8.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10 *[Signature]*

MF 10-8-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 4, 2010 8:57:35 AM

Page 1

Work Order ID: 61016

Parent Item: D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)



Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B2.000X1.750

Purchased

No

f

18.0712

0.26

2.189474



303 BAR 2" X 1.750"



Location

Loc Qty

Loc Code

MAT

17.75866

MAT53

17.75866

0.31251

113310

0.31251

Do. 8. 9

115047

1.92

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61016
Description: D4151-7 FWD CYEBOLT RECEIVER		Part Number: D4151-7
Inspection Dwg:	Rev: 13	Page 1 of 1

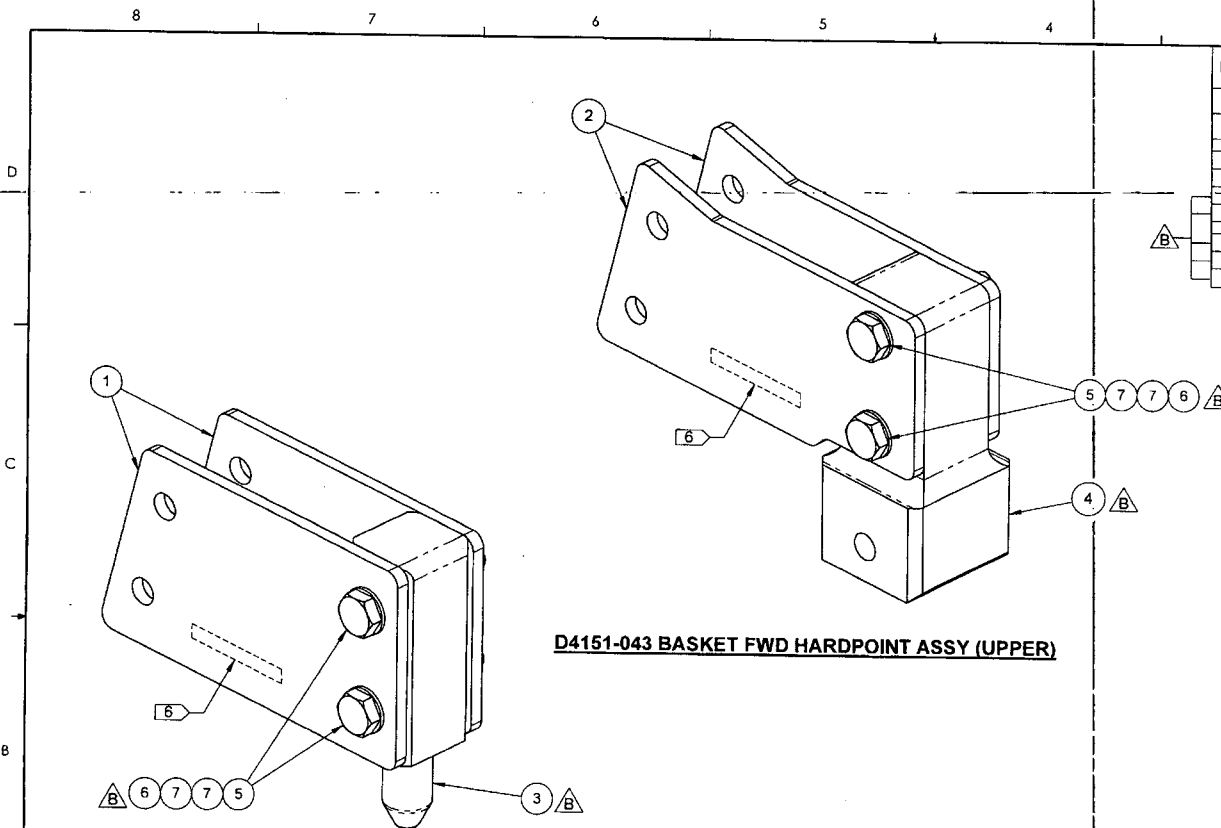
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/- .010	1.251	/		Vern.	
1.250	+/- .010	1.247	/		"	
.625	+/- .010	.625	/		"	
1.00	+/- .030	1.000	/		"	
.125	+/- .010	.125	/		"	
.500	+/- .010	.500	/		"	
R.13	+/- .030	.125	/		RAD GAGE.	
1.000	+/- .010	1.000	/		Vern	
.191 Ø	+ .005 - .001	.191	/		"	
2.76	+/- .030	2.76	/		"	
Ø.19	+/- .030	.188	/		RAD GAGE.	
1.110	+/- .010	1.110	/		Vern	
.96	+/- .030	.965	/		"	
.350	+/- .010	.349	/		"	
.09 x 45°	+/- .030	.09	/		"	
.257 Ø	+ .006 - .001	.258	/		"	
.800	+0.0 - .010	.797	/		"	
.225	+/- .010	.223	/		"	
1.80	+/- .030	1.80	/		"	
.88	+/- .030	.88	/		"	
.734	+ .010 - 0.0	.736	/		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 10.8.9	Date: 10/08/10	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN3C13A	BOLT
6	2	2	MS21043-3	NUT
7	4	4	NAS1149C0332R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61016

10-8-04 **RELEASED**
2010-07-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.84 lbs
 - D4151-043 = 1.17 lbs

B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20915-4M20 (ZN C3-1, D3-1 & B6-1); 0.0191 2 PL REPLACES 0.0129 3 PL (ZN C5-2); 0.0191 2 PL REPLACES 0.0129 4 PL (ZN D1-2); REASON: SEE TR-D350-607-2 REV. 8.		MB	10.07.05
A	NEW ISSUE		MB	10.06.22
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DRAWING NO. D4151		REV. B	
CHECKED	SHEET 1 OF 3			
MFG. APPR.	TITLE		SCALE	
APPROVED	BASKET FWD HARDPOINT		NTS	
DE APPR.	DATE 10.07.05			

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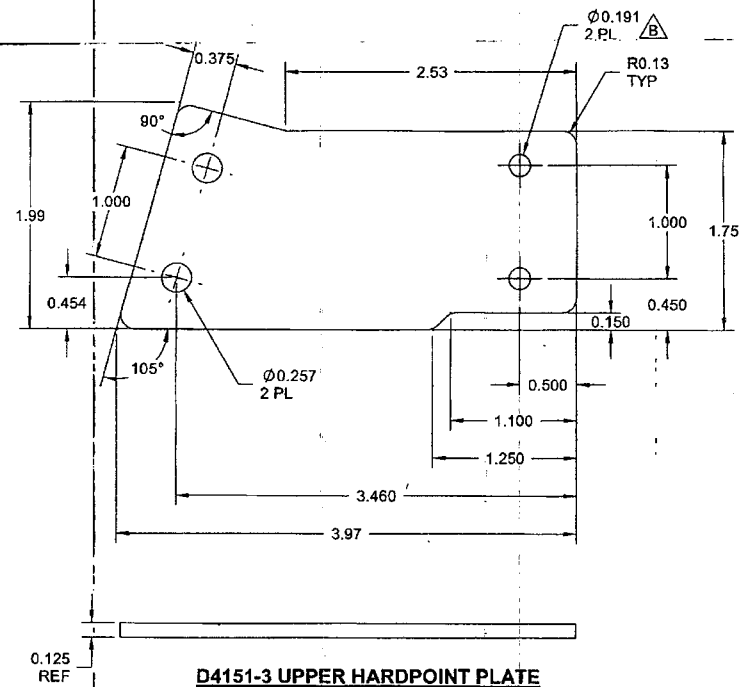
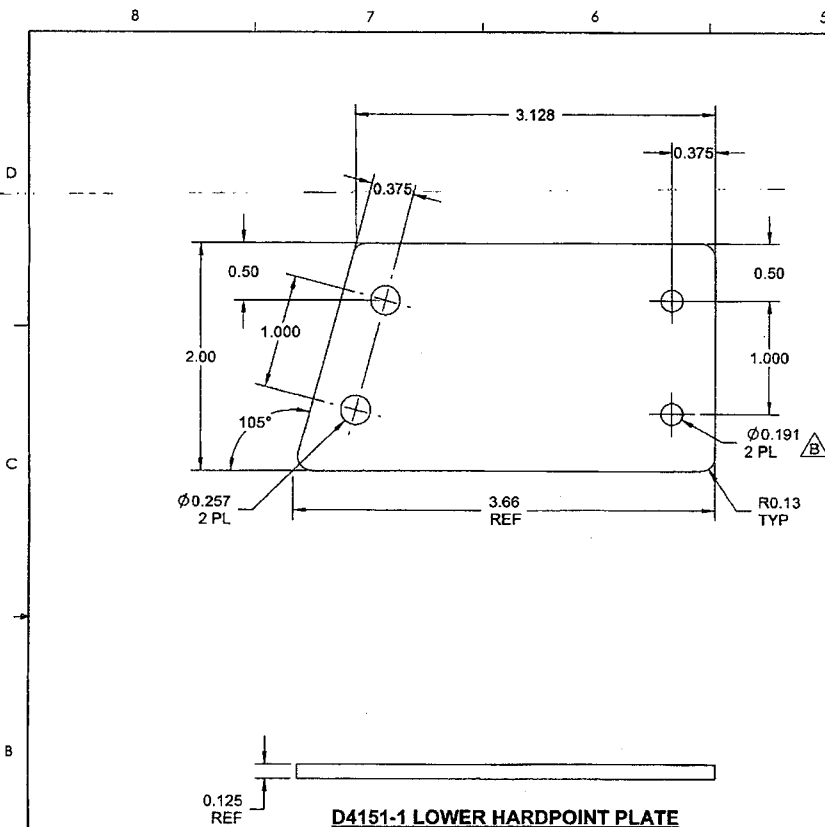
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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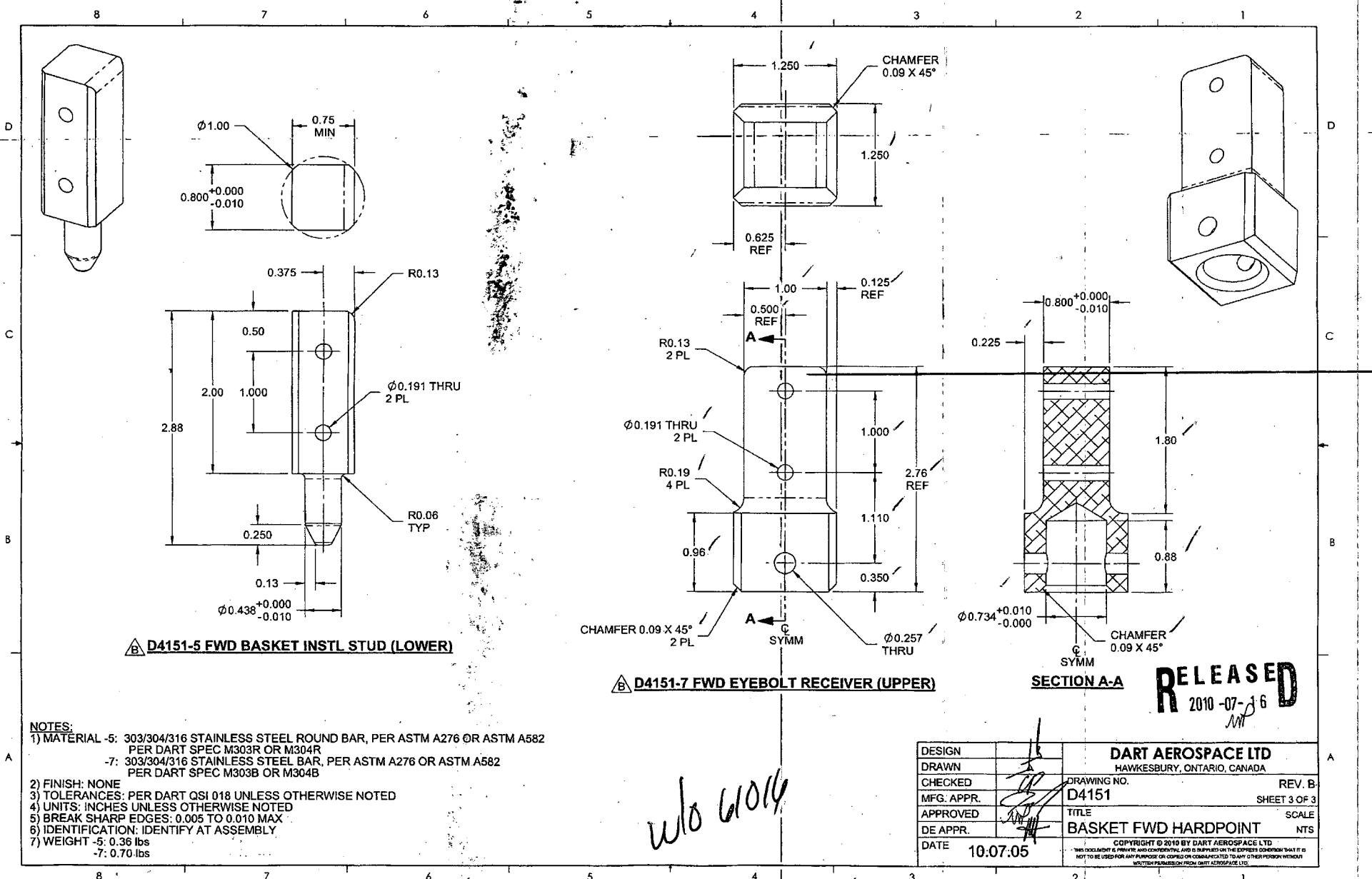
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NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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